

Work Order ID 146069

Friday, May 06, 2016 8:58:46 AM

146069

Page 1

Item ID: K10004 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Heavy Duty Saddle
 Start Date: 4/25/2016 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 5/5/2016 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: sem Date: 16/05/09 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
K10004	Rev E								
100	Document Control	0.00				DAS 27 9-89	21 9-89	16-07-15	(2)
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile for K10004, D205-594-011/-013/-015 & D412-652-011/-21 and type labels per PPP K10004 CHG005								
105	Pick Kit	0.00							
105									
Packaging	Memo	0.00							
Packaging									
110	QC4- 100% Inspect kits for completeness	0.00				DAS 27 9-89			
110									
QC	Memo	0.06							
Quality Control									

JUL 21 2016

JUL 15 2016

JUL 21 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
								Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	

Root Cause				FAULT CATEGORY							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐
Past Expiry Date	☐	Manufacturing Process	☐								
Misidentified	☐	Past Due	☐	OTHER : _____							

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		☐ OTHER : _____							

Picklist Print

Friday, May 06, 2016 8:58:45 AM

Page 1

Work Order ID: 146069

146069

Parent Item: K10004

K10004

Parent Item Name: Heavy Duty Saddle

Start Date: 4/25/2016

Required Date: 5/5/2016

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP: D05.07.22Reformat; Added D3428-3 per CHG003KJ/JLM
 IPP Rev:E 08-09-29 revD as per dwg DD verified by: IPP Rev:F
 chg005 DD 10.06.03 verf:JLM IPP REV:G 13.08.21
 REMOVED D3428-3 DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN4-51A		Purchased	No			105	Each	94.0000	16	32			
AN4-51A													
Bolt													

DAS
27
9-89

Location	Loc Qty	Loc Code
FG	5	
122993	5	
ST340	89	
m134537	38	
m134597	51	

PZ 134851
~~134851~~ x14
 x2 134076
 x16 134016

DAS
31
9-89

AN5-15A		Purchased	No			105	Each	99.0000	32	64			
AN5-15A													
Bolt													

DAS
27
9-89

Location	Loc Qty	Loc Code
GA	11	
m132930	11	
ST337	88	
m132930	48	
m134508	40	

9x PZ 135056
 x15
 40

JUL 15 2016

DAS
31
9-89

134508

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
OTHER : ☐									

Picklist Print

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Page 2

Work Order ID: 146069

146069

Parent Item: K10004

K10004

Parent Item Name: Heavy Duty Saddle

Start Date: 4/25/2016

Required Date: 5/5/2016

Start Qty: 2.00

Required Qty: 2.00

AN5-36A \ Purchased No

105 Each 99.0000 2

99.0000 2

4

M134861 PC

AN5-36A

Bolt

DAS
27
9-89

Location

Loc Qty

Loc Code

over004

80

M134509

40

M134676

40

ST336

19

M130466

15

M134502

4

DAS
31
9-89

AN5-42A \ Purchased No

105 Each 20.0000 2

20.0000 2

4

PC

AN5-42A

Bolt

DAS
27
9-89

Location

Loc Qty

Loc Code

ST336

20

m132930

20

4

DAS
31
9-89

AN5-43A \ Purchased No

105 Each 15.0000 2

15.0000 2

4

PC

AN5-43A

Bolt

DAS
27
9-89

Location

Loc Qty

Loc Code

ST336

15

M128028

5

M134508

10

3
1

DAS
31
9-89

AN5-45A \ Purchased No

105 Each 16.0000 2

16.0000 2

4

PC

AN5-45A

Bolt

DAS
27
9-89

Location

Loc Qty

Loc Code

ST335

16

M127933

16

4

DAS
31
9-89

JUL 15 2016

Friday, May 06, 2016 8:58:45 AM

Shop Packet Print

Page 2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Picklist Print

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Page 3

Work Order ID: 146069

146069

Parent Item: K10004

K10004

Parent Item Name: Heavy Duty Saddle

Start Date: 4/25/2016

Required Date: 5/5/2016

Start Qty: 2.00

Required Qty: 2.00

D205-641-011

Manufactured No

105

Each

0.0000

2

4

D205-641-011

Ground Handing Lugs

D2570

Manufactured No

105

Each

62.0000

32

D2570

Bushing

Location

Loc Qty

Loc Code

DAS
27
9-89

FG
88781
FP001
141497

12
12
50
50

1.0000

2

4

D3407-041

Manufactured No

105

Each

1.0000

2

4

D3407-041

Tow Ring

DAS
27
9-89

Location

Loc Qty

Loc Code

st530
142671

1
1

28.0000

4

8

D3417-5

Manufactured No

105

Each

28.0000

4

8

D3417-5

Washer

DAS
27
9-89

Location

Loc Qty

Loc Code

ST035
140183

28
28

28.0000

4

8

~~147.505 x 2~~
~~147.505 x 2~~
31
9-89
B145728 PC

1X145443 PC
(3x) ~~145442~~
DAS
31
9-89
8X B145908 PC

JUL 15 2016

DAS
31
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
								Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	

Root Cause				FAULT CATEGORY			
Environment ☐	☐ No Re-verification	☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong		
Design ☐	☐ Operator	☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions		
Doc/Data ☐	☐ Offset/Setup	☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance		
Equip/Tooling ☐	☐ Supplier	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect		
Handling/Pre ☐	☐ Training	☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing		
Material ☐	☐ Use for Testing	☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved		
Internal Transport ☐	☐ Poor Information	☐ Crushing	☐ Countersink	☐ Off-set	☐ Drawing		
Tribal Knowledge ☐	☐ Rushing	☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Finish		
LOA ☐	☐ Product Improvement	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread		
Substation ☐	☐ Process Improvement	☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence		
Past Expiry Date ☐	☐ Manufacturing Process	OTHER : _____					
Misidentified ☐	☐ Past Due						

Picklist Print

Friday, May 06, 2016 8:58:45 AM

Work Order ID: 146069

146069

Parent Item: K10004

K10004

Parent Item Name: Heavy Duty Saddle

Start Date: 4/25/2016

Required Date: 5/5/2016

Start Qty: 2.00

Required Qty: 2.00

D3456-1

Manufactured No

105

Each

110.0000

2 4

D3456-1

Washer

**

PC

Location

Loc Qty

Loc Code

FG

7

25701

7

ST038

3

141125

3

ST038A

100

141989

50

144158

50

DAS
27
9-89

DAS
31
9-89

D5951

Manufactured No

105

Each

8.0000

2 4

D5951

Saddle

**

PC

Location

Loc Qty

Loc Code

ST399

8

142235

8

DAS
27
9-89

DAS
31
9-89

D5953

Manufactured No

105

Each

2.0000

2 4

D5953

Saddle

**

B 146754 PC

Location

Loc Qty

Loc Code

ST399

2

131678

2

DAS
27
9-89

DAS
31
9-89

D5955

Manufactured No

105

Each

3.0000

2 4

D5955

Saddle

**

X3 146772 PC

Location

Loc Qty

Loc Code

ST399

3

131703

3

DAS
27
9-89

DAS
31
9-89

JUL 15 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	OTHER : ☐			

Picklist Print

Friday, May 06, 2016 8:58:45 AM

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Work Order ID: 146069

146069

Parent Item: K10004

K10004

Parent Item Name: Heavy Duty Saddle

Start Date: 4/25/2016

Required Date: 5/5/2016

Start Qty: 2.00

Required Qty: 2.00

D5957

Manufactured No

105

Each

1.0000

2

4

4 x 146 955

D5957

Saddle

DAS
27
9-89

Location

Loc Qty

Loc Code

ST399

1

131969

1

MS21042L4

Purchased No

105

Each

1,670.000

16

32

x32 134 955 PC

MS21042L 4

Locknut

Location

Loc Qty

Loc Code

GA

279

m133769

279

OVER007

500

m134676

500

ST303

794

m134606

794

ST305

97

m130922

97

MS21042L5

Purchased No

105

Each

493.0000

40

80

x15 134 955 PC

MS21042L 5

Nut

Location

Loc Qty

Loc Code

GA

115

m127813

115

OVER007

100

m134509

100

ST303

278

m134055

7

m134567

171

m134676

100

DAS
27
9-89

JUL 15 2016

DAS
31
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Picklist Print

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Friday, May 06, 2016 8:58:45 AM

Work Order ID: 146069

146069

Parent Item: K10004

K10004

Parent Item Name: Heavy Duty Saddle

Start Date: 4/25/2016

Required Date: 5/5/2016

Start Qty: 2.00

Required Qty: 2.00

MS21043-4

Purchased

No

105

Each

889.0000

2

4

MS21043-4

Nut

PC

Location

Loc Qty

Loc Code

FG	40	
104603	40	
GA	95	
m132803	95	
OVER007	300	
m134502	300	
ST302	454	
m133769	12	
m134249	142	
m134634	300	

DAS
27
9-89

DAS
31
9-89

DAS
31
9-89

NAS1149D0563J

Purchased

No

105

Each

1,244.000

80

160

NAS1149D0563.J

Washer

40x135058 PC

Location

Loc Qty

Loc Code

GA	261	
m125807	2	
m133769	259	
ST263	884	
m134497	884	
ST269	99	
m128257	99	

DAS
27
9-89

JUL 15 2016

DAS
31
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER : _____							

THIS KIT CONTAINS PARTS AND PAPERWORK APPLICABLE TO THE FOLLOWING
LANDING GEAR INSTALLATIONS:

AIRCRAFT	INSTALLATION
BELL 412	D412-652-011 D412-652-021
BELL 205/212/214	D205-594-011 D205-594-013 D205-594-015
BELL 204	D205-594-021 D205-594-023

THE FOLLOWING PARTS SHOULD BE USED PER THE RELEVANT DRAWINGS AND THE
FOLLOWING TABLE (REF):

PART NUMBER	K10004	D412-652-011 D412-652-021	D205-594-011 D205-594-013 D205-594-015 D205-594-021 D205-594-023
D205-641-011	2	2	2
D2570	32	32	32
D3407-041	2	2	2
D3417-5	4	4	4
D3428-3*	1	N/A	1
D3456-1	2	2	2
D5951	2	2	2
D5953	2	2	2
D5955	2	2	2
D5957	2	2	2
AN4-51A	16	16	16
AN5-15A	32	32	32
AN5-36A	2	2	2
AN5-42A	2	2	2
AN5-43A	2	2	2
AN5-45A	2	2	2
AN960JD516	80	80	80
MS21042-4 (OR L4)	16	16	16
MS21042-5 (OR L5)	40	40	40
MS21043-4	2	2	2

*REQUIRED WITH D205-594-011/-013 INSTALLATIONS ON 214 AIRCRAFT ONLY

E	D3407-041 WAS D3407-045; REMOVE D3812-1; REASON: TOW RING IS CHANGED ON D205-634-011/ D204- 635-011 SKIDTUBES @ CHG 007 AND D205-634-015 SKIDTUBES @ CHG 006. SEE DSI 9417/9418 @ REV. B	PH	09.01.28
D	D3407-045 WAS D2707-041; D3456-1 WAS AN970-4; MS21043-4 REPLACES MS21042-4 (QTY 2); ADD D3417-5 AND D3812-1; ADD REFERENCE TO D205-594-021/-023	PH	08.09.11
C	ADD D3428-3 PLACARD	PH	05.07.22
B	ADD D2707-041 OPTION	DS	00.11.22
A	NEW ISSUE	DS	00.06.01
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD	
DRAWN	AS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		K10004	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		SADDLE KIT	NTS
DATE	09.01.28	COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

2/10/14/01/09

Rev 16/05/09

THIS KIT CONTAINS PARTS AND PAPERWORK APPLICABLE TO THE FOLLOWING
LANDING GEAR INSTALLATIONS:

AIRCRAFT	INSTALLATION
BELL 412	D412-652-011 D412-652-021
BELL 205/212/214	D205-594-011 D205-594-013 D205-594-015
BELL 204	D205-594-021 D205-594-023

THE FOLLOWING PARTS SHOULD BE USED PER THE RELEVANT DRAWINGS AND THE
FOLLOWING TABLE (REF):

PART NUMBER	K10004	D412-652-011 D412-652-021	D205-594-011 D205-594-013 D205-594-015 D205-594-021 D205-594-023
D205-641-011	2	2	2
D2570 L	32	32	32
D3407-041	2	2	2
D3417-5	4	4	4
D3428-3*	1	N/A	1
D3456-1	2	2	2
D5951	2	2	2
D5953	2	2	2
D5955	2	2	2
D5957	2	2	2
AN4-51A	16	16	16
AN5-15A	32	32	32
AN5-36A	2	2	2
AN5-42A	2	2	2
AN5-43A	2	2	2
AN5-45A	2	2	2
AN960JD516	80	80	80
MS21042-4 (OR L4)	16	16	16
MS21042-5 (OR L5)	40	40	40
MS21043-4	2	2	2

*REQUIRED WITH D205-594-011/-013 INSTALLATIONS ON 214 AIRCRAFT ONLY

E	D3407-041 WAS D3407-045; REMOVE D3812-1; REASON: TOW RING IS CHANGED ON D205-634-011/ D204-635-011 SKIDTUBES @ CHG 007 AND D205-634-015 SKIDTUBES @ CHG 006. SEE DSI 9417/9418 @ REV. 8	PH	09.01.28
D	D3407-045 WAS D2707-041; D3456-1 WAS AN970-4; MS21043-4 REPLACES MS21042-4 (QTY 2); ADD D3417-5 AND D3812-1; ADD REFERENCE TO D205-594-021/-023	PH	08.09.11
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DRAWN	AS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		K10004	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		SADDLE KIT	NTS
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